

Date: Tuesday, 3/27/2007 7:56:59 AM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 31513	
Estimate Number : 12811	
P.O. Number : N/A	Part Number : D35921
This Issue : 3/27/2007 S.O. No. : N/A	Drawing Number : D3592 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : REVA
Previous Run : N/A	Material : N/A
Written By : _____	Due Date : 4/3/2007
Checked & Approved By : _____	Qty : 3 Um : Each
Comment : Est Rev:A New Issue 07-03.26 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S125	6061-T6 .125 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.1460 sf(s)/Unit Total: 0.1460 sf(s) , 2920
 6061-T6 .125 Sheet
 Batch: M103156 ml 07 03 27 (3)

Grain must be Along 4.63**

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3592
 Dwg Rev: A ml 07 03 27 (3)
 Prog Rev: A

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE ml 07 03 27 (3)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK ml 07 03 29 (2)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1 ml 07 03 29 (2)

Form as per Dwg D3592

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31513

Part Number: D35921

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 04-04-05

1-07/04/05

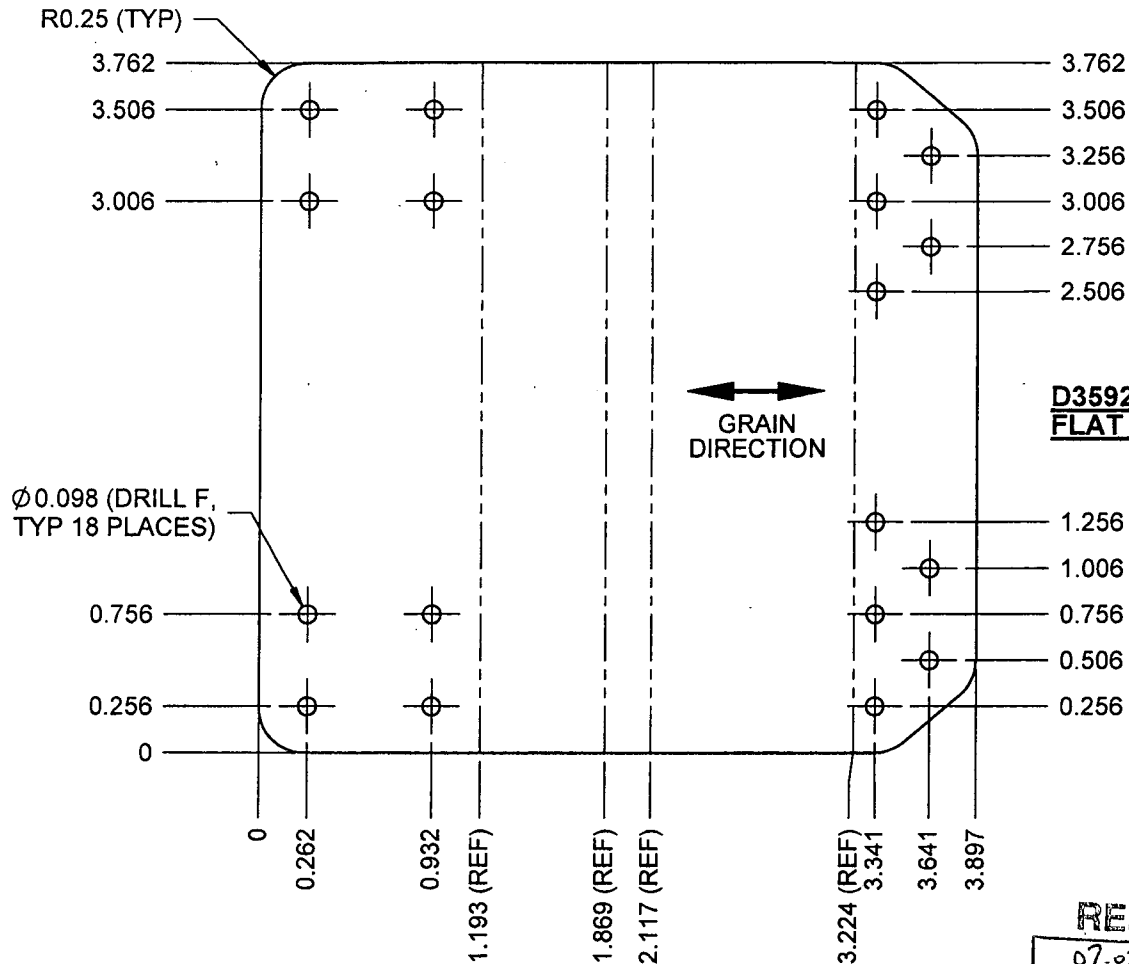
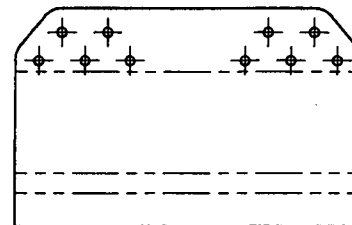
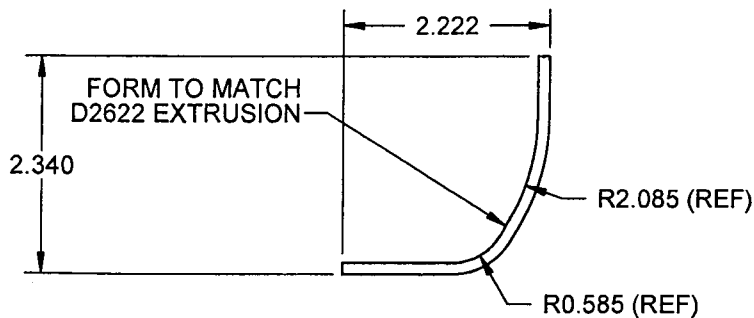
foldy step

00075

No item stock

DART

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3592	REV. A SHEET 1 OF 1
DATE 07.01.15	TITLE PLATE		SCALE 1:1
A	07.01.15	NEW ISSUE	

**RELEASED**07-02-20 *[Signature]***BEND DETAIL**
SCALE 1:2**D3592-1 PLATE****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.125)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order: 31513
Description: Bracket		Part Number: D3592-1
Inspection Dwg: D3592 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.098$	+0.004-0.001	0.100	✓		vern	
B 3.762	+/- 0.010	3.770	✓		vern	
C 3.897	+/- 0.010	3.905	✓		vern	
D 0.256	+/- 0.010	0.260	✓		vern	
E 0.756	+/- 0.010	0.760	✓		vern	
F 3.006	+/- 0.010	3.010	✓		vern	
G 3.506	+/- 0.010	3.510	✓		vern	
H 0.262	+/- 0.010	0.260	✓		vern	
I 0.932	+/- 0.010	0.930	✓		vern	
J 3.341	+/- 0.010	3.340	✓		vern	
K 3.641	+/- 0.010	3.641	✓		vern	
L 1.256	+/- 0.010	1.251	✓		vern	
M 2.506	+/- 0.010	2.500	✓		vern	
N R0.25	+/- 0.030	R0.25	✓		vern Radius Gauge	
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>mdl. jwl</i>	Audited by:	Prototype Approval:	N/A
Date: 07 03 27	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	